

A1 Hex 10

Work Order ID 75978

75978

Page 1

November-02-11 10:49:02 AM

Item ID: D3299-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fitting
 Start Date: 02/11/2011 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/02 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3299	Rev C

100 . 0.00
 100 Hardinge CNC LATHE SMALL
 Doosan Memo 0.00

Doosan Lathe Machine as per Folio FA452 and Dwg D3299
 Check NPT THREAD WITH SAMPLE IN TOOLING RACK UNDER D3399-1
 FOLIO REV: C
 DWG REV: C
 Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110 QC Memo 0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75978

November-02-11 10:49:02 AM

75978

Page 3

Item ID: D3299-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 02/11/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: **37**

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/1/12
MF
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:49:07 AM

Page 1

Work Order ID: 75978

75978

Parent Item: D3299-3

D3299-3

Parent Item Name: Fitting

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A04.10.04New issueKJ/JLM
PER REV C 10-01-19 JLM VERIFIED BY:EC

IPP REV:B AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6H1.000

Purchased

No

100

f

19.9880

0.1833

1.543579

M6061T6H1 000

6061-T6 HexBar 1.00

**

11/16/17

Location

Loc Qty

Loc Code

MAT012

19.988

109478

1.721

116623

5.797

119275

12.47

1-13
= 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75978
Description: Fitting		Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	.995	/	/		
Ø0.302	+0.005/-0.000	Ø.304	/	/		
0.550	+/-0.010	.552	/	/		
0.63	+/-0.030	.632	/	/		
2.08	+/-0.030	2.085	/	/		
0.900	+/-0.010	.910	/	/		
53°	+/-0.5°	53°	/	/		
0.476	-0.005/+0.000	.474	/	/		
MOW for 9/16"-18	Min = 0.57088 Max = 0.5743	.5725	/	/		
0.200	+/-0.030	.200	/	/		
0.450	+/-0.010	.450	/	/		
0.10	+/-0.030	.130	/	/		
Length of Engagement for 1/4 NPT 0.227	+/-0.010	.225	/	/	T.G	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11/11/17	Date:	11/11/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	
D	08.10.24	Tolerances updated	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

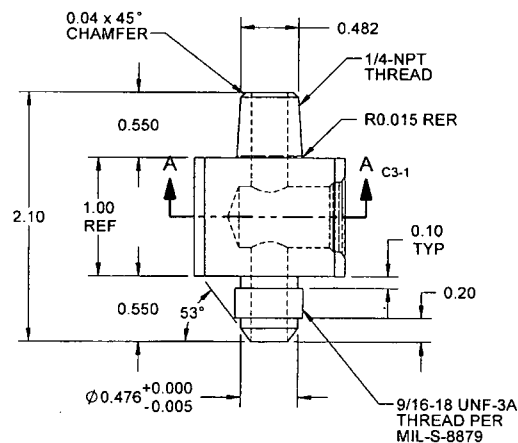
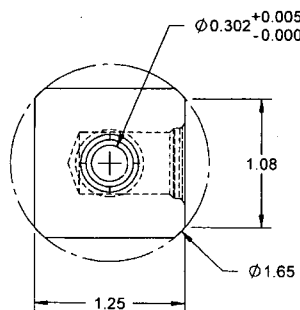
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75978 Y.C.J

11/11/07



D3299-1 FITTING

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2

POSSIBLE SUPPLIER: ANODIZING TNM PAINT

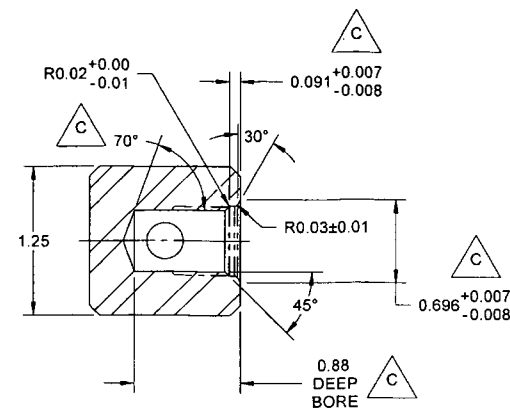
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

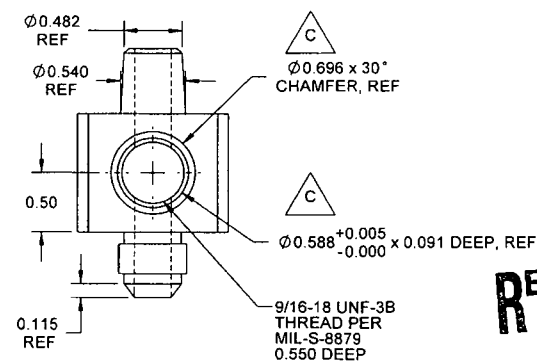
5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-1" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.42 lbs



SECTION A-A C5-1



RELEASED
2010-01-14

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISE MATERIAL BAR WAS HEX BAR (ZN A8-1); ADD -7 (ZN A4-4); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN D2-1, D3-1, C2-1, B2-1, D5-4, C4-4, B4-4, C1-4) PER CAR 09-004	RF	09.12.30
B	1.09 WAS 0.837; 0.302 WAS 0.297	RF	05.04.28
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

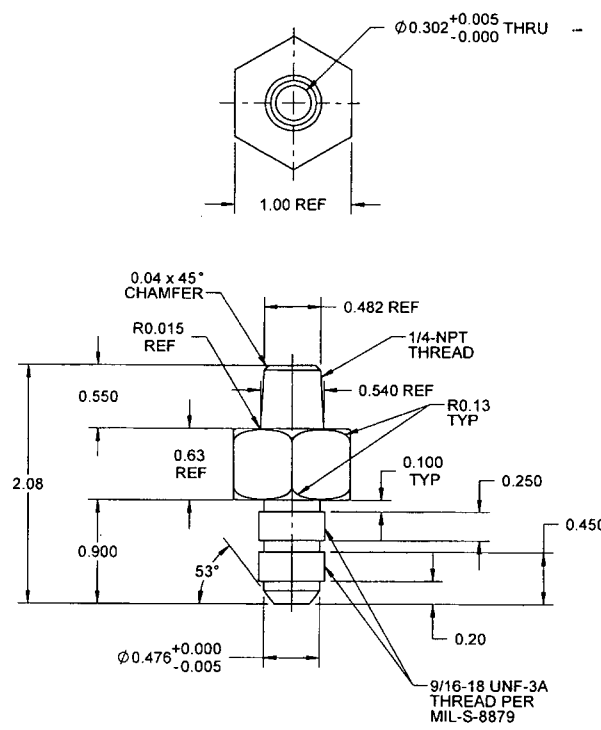
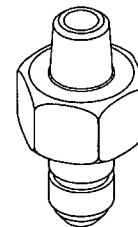
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75978



D3299-3 FITTING

RELEASED
2010-01-14

- NOTES:**
 MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.00" HEX BAR
 PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6H1.000
 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
 POSSIBLE SUPPLIER: ANODIZING TNN PAINT
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-3" & B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.20 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3299	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

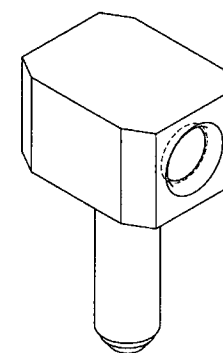
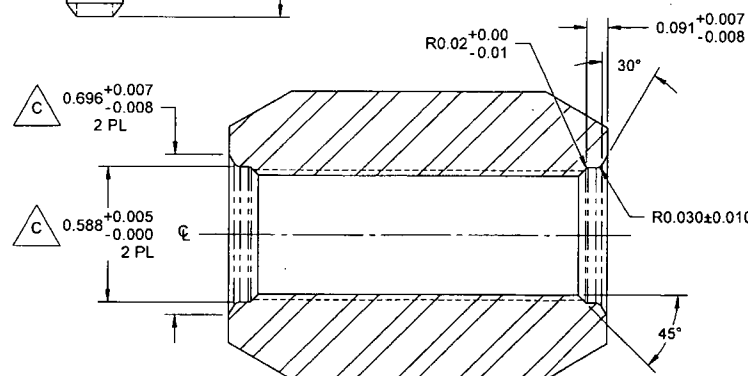
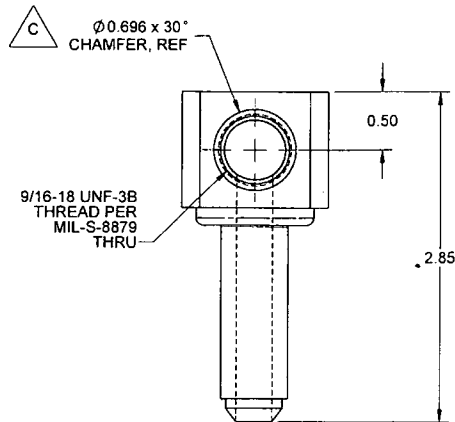
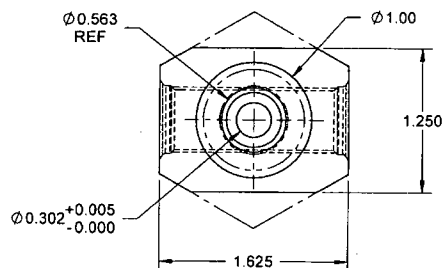
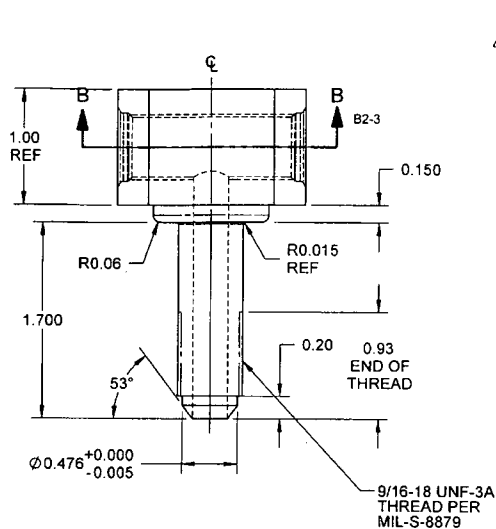
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75978



SECTION B-B D6-3
SCALE 2X

RELEASED
2010-01-14

D3299-5 FITTING

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNN PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-5" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

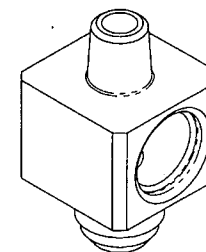
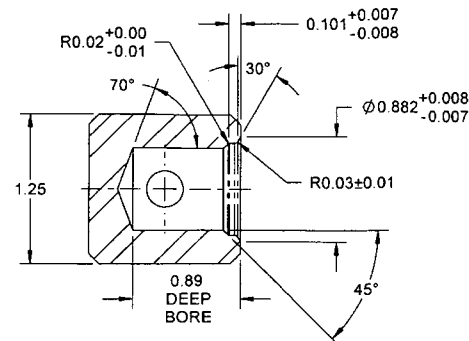
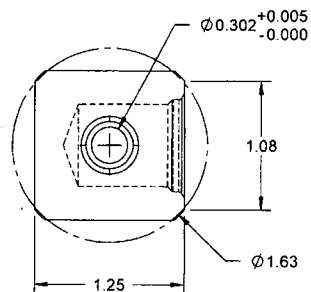
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

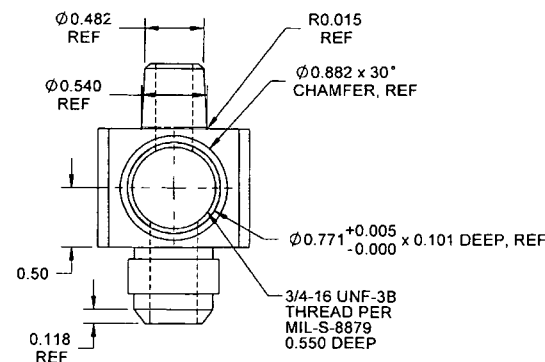
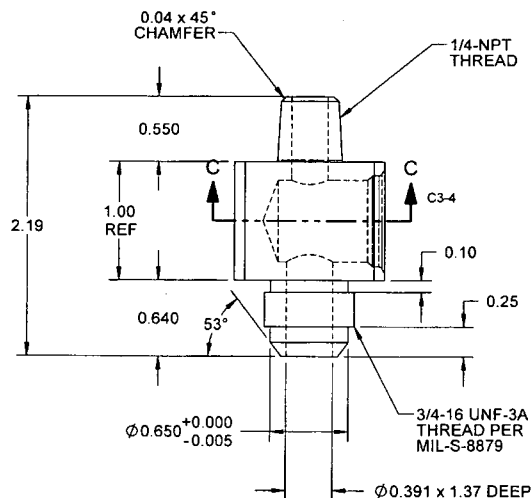
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75970



SECTION C-C C5-4



D3299-7 FITTING

RELEASED
2010-01-16
MP

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-7" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.40 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15786**

Purchase Order Date 1/04/12

PO Print Date 1/09/12

Page Number 1 of 2

Order From :

VC-ROY003

ROYAL BANK VISA

X

X, X

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

COD

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

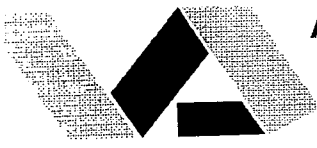
Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	75978	D3299-3 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				
2	75979	D3299-5 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				
3	75977	D3299-7 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				

PO Instructions: VERDUN ANODIZING (ATTN: MARC FOURNIER)
VISA ACCT: 4516 0500 0053 0448 EXP: 0514 CID: 327

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 1/09/12



Anodisation Verdun Inc.
Verdun Anodizing Inc.
3971, ave Verdun, Verdun (Quebec) H4G 1L1

AS 9100:2004
ISO 9001:2000
Certified

info@verdunanodizing.com
Tel: (514) 761-4531
Fax: (514) 769-4731

PACKING SLIP

DARTAERO

DARTAERO

C
U
S
T
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M
E
R

DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

S
H
I
P
DART AEROSPACE LTD.
1270, ABERDEEN STREET

T
O
HAWKESBURY
Ontario K6A 1K7

[C]

Customer Copy

Attn: CHANTAL LAVOIE 1-613-632-9577 Fax: (613)-632-1053

Customer Order No.	Order Date	Ship Via	No. of Packages	Date Shipped	Reference No.
PO15786	05/01/12	FEDEX	1	09/01/12	273222-00

MIL221BL

Bleu Sulfuric Anodize: DIW S Rev: F1

Item No.	Part No.	Description	Serial No.	Length	Quantities	
					Processed	Not processed
001	D3299-3	MAT:			8.0	
	LINE:1 FITTING REF:75978					
002	D3299-5	MAT:			8.0	
	LINE:2 FITTING REF.75979					
003	D3299-7	MAT:			8.0	
	LINE:3 FITTING REF.75977					

Total: 24.0 0.0

Remarks:

Customer signature



Anodisation Verdun Inc.
Verdun Anodizing Inc.
3971, ave Verdun, Verdun (Quebec) H4G 1L1

AS 9100:2004
ISO 9001:2000
Certified

info@verdunanodizing.com
Tel: (514) 761-4531
Fax: (514) 769-4731

CERTIFICATE OF SUB-CONTRACTOR

DARTAERO

DARTAERO

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DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

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DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

Customer Order No.	Order Date	Process Date	Certificate No.
PO15786	05/01/12	09/01/12	273222-00

PROCESS: MIL A-8625F1 Ty II Cl 2 BLEU DIW Seal

Item No.	Quantity	Description	Serial #
001	8.0	D3299-3 LINE:1 FITTING REF:75978 MAT: <i>812/10/10</i>	
002	8.0	D3299-5 LINE:2 FITTING REF.75979 MAT:	
003	8.0	D3299-7 LINE:3 FITTING REF.75977 MAT:	

We hereby certify that the parts described above and furnished by DART AEROSPACE LTD. have been treated in accordance with the relevant specifications and that no substitution of materials has been made.

[Signature]
Inspector: Verdun Anodizing Inc.